

Date: Wednesday, 3/26/2008 9:54:18 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MAINTENANCE STEP, RH
 Job Number : 38181
 Estimate Number : 11284
 P.O. Number :
 This Issue : 3/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3436044
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3436 REV A
 Previous Run : 35446 Project Number : N/A
 Material :
 Due Date : 4/2/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JD 08.3.27
 Comment : EsT A 05.05.11 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34361 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1 D3436-1 Clamp 338193

JD 08.03.31 4

2.0 D34364 Right Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

RH Step

Pick:

Qty Part Number Description Batch

1 D3436-4 LH Step 338195

JD 08.03.31 4

3.0 D34365 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

✓ 4 D3436-5 Bushing 323357

JD 08.03.31 4

4.0 D34367 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1 D3436-7 Cap 338196

JD 08.03.31 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:18 AM
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Drawing Name: MAINTENANCE STEP, RH

Job Number: 38181

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A

Qty	Part Number	Description	Batch
A/RN/A	4130 Welding Rod	M100075	

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/RN/A	4130 Welding Rod	M100075	

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/RN/A	4130 Welding Rod	M100075	

08-03-31 4

08-03-31 4

08-03-31 4

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

Slit part D3436-041 on bandsaw as per Dwg D3436

08-04-1 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/01 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/01 (4)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

08/04/01 (4)

10.0

POWDER COATING

POWDER COATING



M107550



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI-005 4.4

M-1 08/04/01

→

FL 08/04/02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Drawing Name: MAINTENANCE STEP, RH

Job Number: 38181

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EB 08/04/02 (9)

12.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description

2 D3436-9 Pad

A/R N/A Contact Cement

Batch

B23359
M102565

(5)

B

38191 (3)

EB 08/04/02

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(08/04/02) (4/10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST455

AS 08/04/02

(x4)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/02
KA

Job Completion



U 08/04/02



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

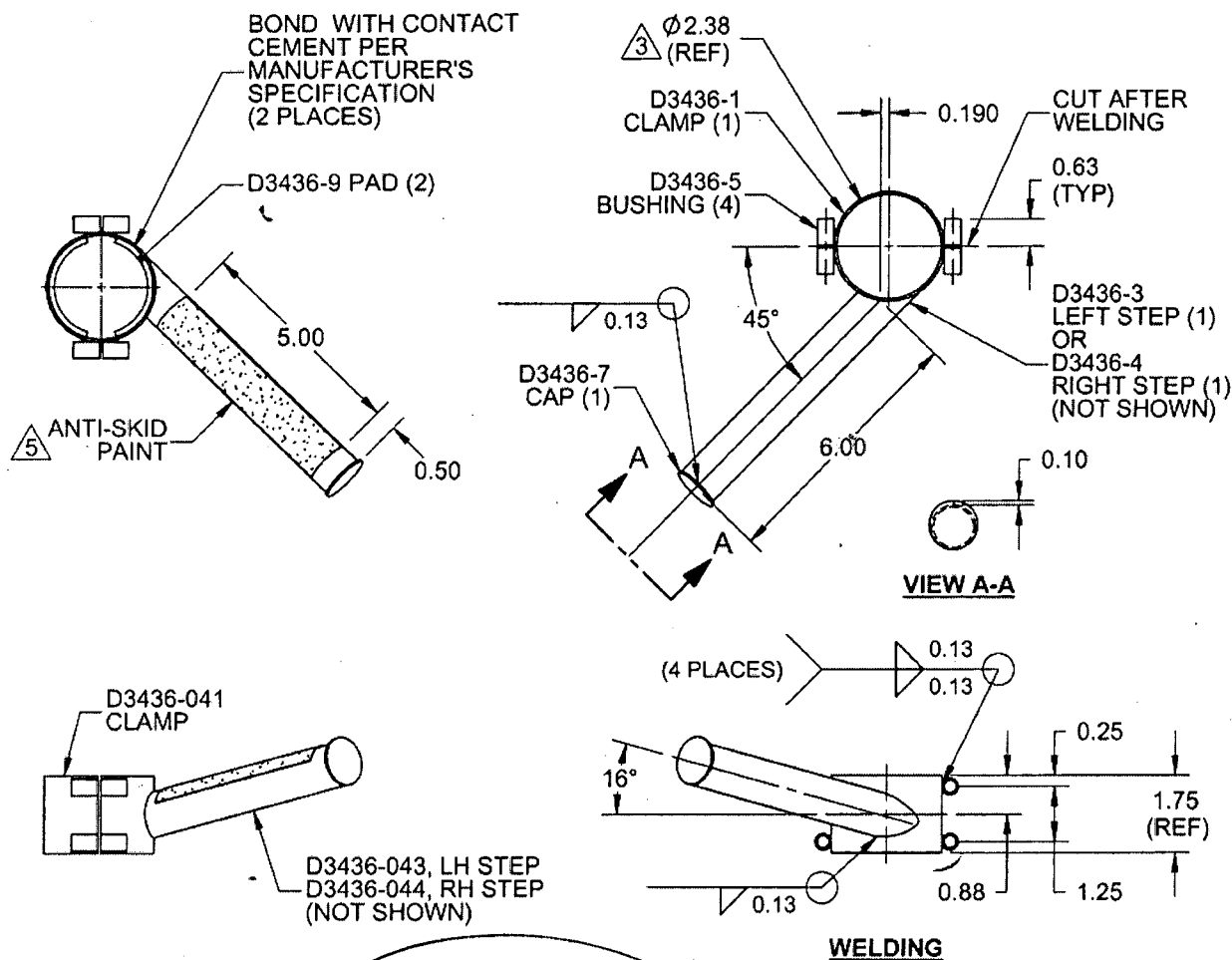
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.21

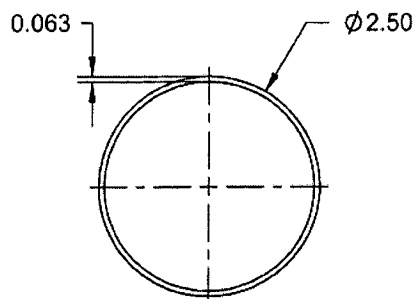
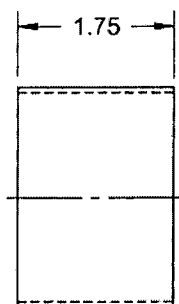
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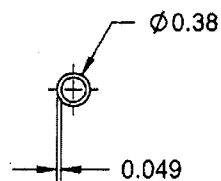
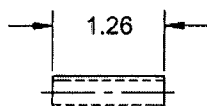


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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 *[Signature]*

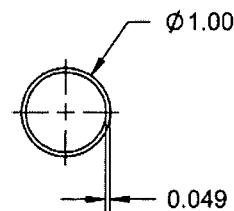
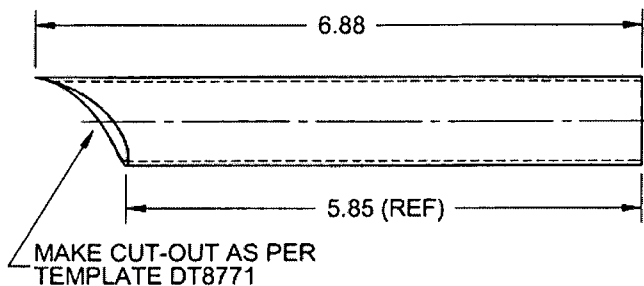
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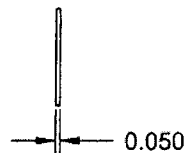
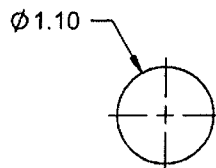
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DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

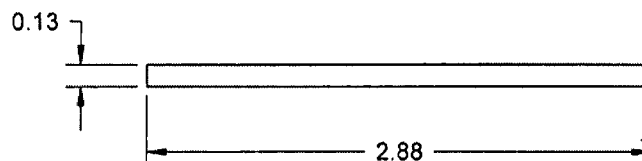
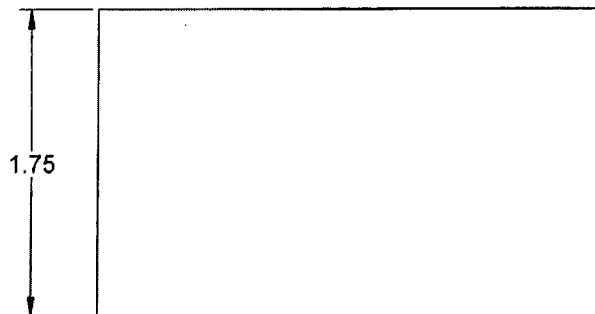
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED

05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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